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RBW6705G02732-3G-1

Job Sheet 187948



Part No: RBW6705G02732-3G-1

Job Qty: 5 ea

Part Name: Stroke Gag, T/R Actuator



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/21/18

Job Tracking No:

Due Date: 12/21/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBW6705G02732-3G Rev C IPP Rev A 17.11.20 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea		12/21/18	0.00	0.00	Start Up Machining		JK
110	Mori Seiki	5 pcs		12/21/18	0.00	2.50	SL2500Y		JK
120	QC	5 pcs		12/21/18	0.00	0.00	QC2		JK
122	Mori Seiki	5 pcs		12/21/18	0.00	2.50	SL-154		JK
124	QC	5 pcs		12/21/18	0.00	0.00	QC2 Machining-5		JK
126	Mill Conv	5 pcs		12/21/18	0.00	2.50	Conv Mill 1		JK 19-4-16
128	QC	5 pcs		12/21/18	0.00	0.00	QC2 Machining-5		JK 19-4-16
130	QC	5 pcs		12/21/18	0.00	0.00	QC8		JK 19-4-16
140	Packaging	5 pcs		12/21/18	0.00	0.00	Packaging3		28
150	QC21-SA	5 Ea		12/21/18	0.00	0.00	QC21		9-89

Part Op 110 - 1-Machine as per folio FB680 FOLIO REV: AA DWG REV: C 2-Debur
Descriptions: 122 - 1-Machine as per folio FB680 FOLIO REV: AA DWG REV: C 2-Debur
126 - 1-Machine as per DWG 2-Debur

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELINR1.625W	M Delrin Round Bar, White	.8300 ft (.166 ea)	90-Start up Operation	5039758

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MDELINR1.625W	1	5	0

Part Specifications

Specifications could not be found.



Container No: S140016



Part: RBW6705G02732 - 3G - 1

Job No: 187948

Serial No/Batch: S140016

Revision: C

Inspector:

Exp Date:

Instructions:

Date: 12/21/18

Plex 12/21/18 1:19 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

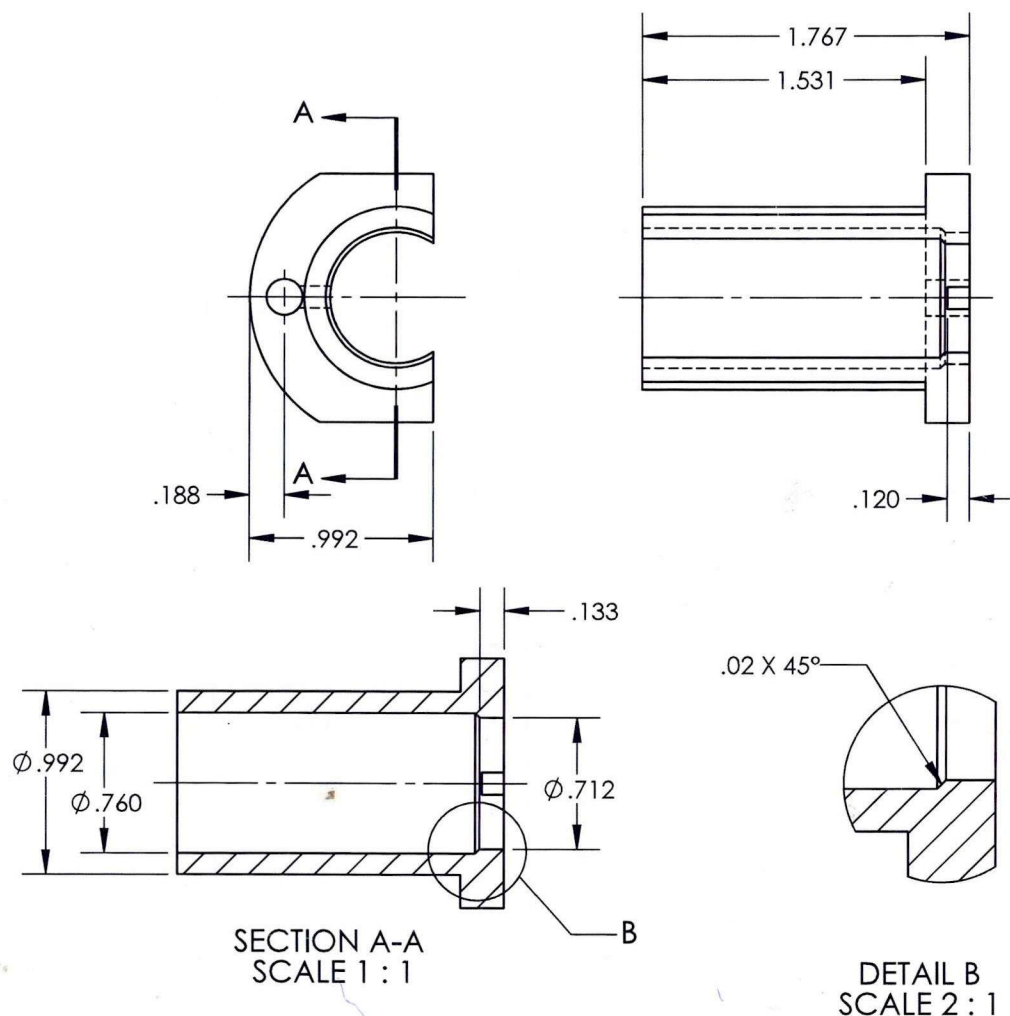
NCR No. _____

Route update only ☐

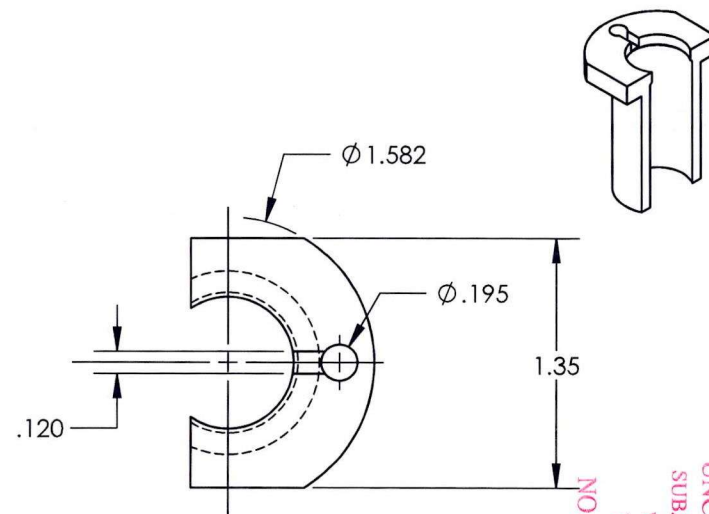
Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																															
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042)																													
Description Work Order Deviation				Disposition																															
				Completed By																															
				Lead hand / Supervisor																															
				QC / QA Coordinator																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"><tr><td>☐ Pressure/Forced</td><td>☐ Contamination</td><td>☐ Power Loss/Surge</td><td>☐ Positioned Wrong</td></tr><tr><td>☐ Bending</td><td>☐ Misaligned/off center</td><td>☐ Folio/Program</td><td>☐ Outside Tolerance</td></tr><tr><td>☐ Crushing</td><td>☐ BOM/Route</td><td>☐ Grain Direction</td><td>☐ Drawing</td></tr><tr><td>☐ Cracks</td><td>☐ Broken/Damage/Defect</td><td>☐ Weld</td><td>☐ Finish</td></tr><tr><td>☐ Crimp/Kink/Ripple/Wave/Twist</td><td>☐ Incomplete/Unclear Instructions</td><td>☐ Wrong Stock Pulled</td><td>☐ Part Lost/Missing</td></tr><tr><td>☐ Marks/Chatter</td><td>☐ Drill Holes</td><td>☐ Out of Sequence</td><td>☐ Misread</td></tr><tr><td>☐ Mislabeled</td><td>☐ Fit/Function</td><td>☐ Off-set/Set-up</td><td></td></tr></table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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		Other/Details:																																	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		CORRECTED T/N ON -9. ADDED NOTE 2 & MADE SECTION A-A VIEW FOR CLARITY PER GE.	4/25/2011	RJC	RW
C	14-0135	-1 ADDED DETAIL B. CH'D DIMS WAS .180 IS .188, WAS .997 IS .992, WAS 1.288 IS 1.531, WAS 1.498 IS 1.767. ADDED DIMS 1.35 & .02 X 45°.	8/18/2014	DPD	RJC



STROKE GAG, T/R ACTUATOR



NOTE:
SOME HIDDEN LINES OMITTED FOR CLARITY.

DART AEROSPACE	
TITLE STROKE GAG, T/R ACTUATOR	
DWG NO. RBW6705G02732-3G-1	REV C
MAT'L WHITE DELRIN	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AGUSTA
SCALE 1:1	DATE 1/28/2010
SHEET 2 OF 2	

SHOP COPY
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 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER NO. 184984CS
 18-10-14

DART AEROSPACE LTD		Work Order:	
Description: <i>STROKE GAG, T/R ACTUATOR</i>		Part Number:	<i>RBW6705602732-36-1</i>
Inspection Dwg: <i>RBW6705602732-36-1 REV: C</i>		Page 1 of 1	

INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
CNC						
<i>1.767</i>	$\pm .005$	<i>1.767</i>	☒	☐		
<i>1.531</i>	$\pm .005$	<i>1.530</i>	☒	☐		
<i>Ø1.582</i>	$\pm .005$	<i>1.583</i>	☒	☐		
<i>.02 x 45°</i>	$\pm .01 \quad \pm .5^\circ$	<i>.02 x 45°</i>	☒	☐		
<i>Ø0.712</i>	$\pm .005$	<i>.714</i>	☒	☐		
<i>Ø0.760</i>	$\pm .005$	<i>.760</i>	☒	☐		
<i>Ø0.992</i>	$\pm .005$	<i>.993</i>	☒	☐		
<i>0.133</i>	$\pm .005$	<i>.134</i>	☒	☐		
<i>.120</i>	$\pm .005$	<i>.120</i>	☒	☐		
<i>Ø.195</i>	$\pm .005$	<i>.196</i>	☒	☐		
<i>.188</i>	$\pm .005$	<i>.188</i>	☒	☐		
<i>1.35</i>	$\pm .01$	<i>1.355</i>	☒	☐		
Manual Milling						
<i>.992</i>	$\pm .005$	<i>.993</i>	☒	☐	<i>FL05</i>	
<i>1.35</i>	$\pm .010$	<i>1.354</i>	☒	☐		

Measured by: <i>JK</i>	Audited by: <i>BA</i>	Preliminary Approval:
Date: <i>18-12-2018</i>	Date: <i>19-04-16</i>	Date:

Rev	Date	Change	Revised by	Approved
A	14.07.14	New Issue	KJ	